

Ship 05/09 GPUT

Dart Aerospace Ltd.

Date: Wednesday, 20/08/2008 12:49:16 PM  
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: COLLECTIVE LOCK
Job Number	: 41527		
Estimate Number	: 11948		
P.O. Number	:	Part Number	: D3372041
This Issue	: 20/08/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3372 REV B
First Issue	: 11	Project Number	: N/A
Previous Run	: 32850	Drawing Revision	: B
		Type	: SMALL /MED FAB
		Material	:
Written By	:	Due Date	: 04/09/2008
Checked & Approved By	:	Qty:	4 Um: Each
Comment	: Est Rev:A Removed from 9 Digit 06-01-13 JLM		
	: Est Rev:B Added Key ID ____ 06.03.21 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D27287	Label
Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)		
Pick:		
Qty Part Number Description Batch		
1 D2728-7 Decal 22554 SAD 08/09/07 4		
2.0	D33721	Main Body
Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)		
Pick:		
Qty Part Number Description Batch		
1 D3372-1 Main Body B41526 SAD 08/09/07 4		
3.0	D33725	Cam Lock Shaft
Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)		
Pick:		
Qty Part Number Description Batch		
1 D3372-5 Cam Lock Shaft B2290 SAD 08/09/07 4		
4.0	D33727	Slider Body
Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)		
Pick:		
Qty Part Number Description Batch		
1 D3372-7 Slider Body 22291 SAD 08/09/07 4		





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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33731

Cam Lock



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description

1 D3373-1 Cam Lock

Keys alike keys dislike

B 420A+B

22610

22944

26212 \*\*\*CHECK WITH PRODUCTION IF KEYED ALIKE OR UNALIKE\*\*\*

SAD 08/09/07 4

6.0

AN542A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN5-42A Bolt 108089

SAD 08/09/07 4

7.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 5/16WC SS Flat Washer 106869

A/RN/ALocktite 262 1107045

SAD 08/09/07 4

8.0

D33841

Cyclic Sock



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3384-1 Cyclic Sock 1337172

SAD 08/09/07 4

9.0

CBL460

Loop Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CBL-460 Loop Sleeve 1107234

SAD 08/09/07 4

1. The first part of the paper is devoted to a general  
 introduction of the subject and to a brief review of the  
 literature on the subject. The second part is devoted to a  
 detailed study of the problem. The third part is devoted to a  
 study of the problem from a different point of view. The  
 fourth part is devoted to a study of the problem from a  
 different point of view. The fifth part is devoted to a  
 study of the problem from a different point of view.



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Seq. #: Machine Or Operation: Description :

10.0 CBL1240 Cable



Comment: Qty.: 0.6999 f(s)/Unit Total: 2.7997 f(s)

Pick:

Qty Part Number Description Batch

8" CBL-1240 Cable

~~24159~~  
7103427

SAD 08/09/07

4

11.0 AN960416 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960-416 Washer

15519

SAD 08/09/07

4

12.0 HX81 1/4"-20 SHCS 3/8" long



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HX-81 1/4"-20 SHCS 3/8" long

16976

SAD 08/09/07

4

13.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372

Identify as D3372-3

SAD 08/09/07

4

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 08/09/07 (4)

15.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.

2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as D3369-5

SAD 08/09/08 (4)





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Job Number:



Seq. #: Machine Or Operation: Description :

16.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads

Qty Part Number Description Batch

A/R N/A Locktite 262 M107045

Identify as D3372-053

2-Assemble D3372-051 as per Dwg D3372. Identify as D3372-051 and attach keys Ensure that assembly locks and unlocks smoothly.

3-Assemble lanyard to cyclic sock as per Dwg D3384

4-Assemble D3384-043 to D3372-051 using 1/4"-20 socket head cap screw and washers as per Dwg D3371.

SAD 08/09/08 (4)

17.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Tack weld lock shaft as per Dwg D3372

Qty Part Number Description Batch

A/R N/A SS Rod M107051

PD 08-09-09 (2)

18.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

108/09/09 (2)

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/09 (2)

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Record Keys alike #

Record Keys dislike #

C4204

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

1890

1891

1892

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1906

1907



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Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/09 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



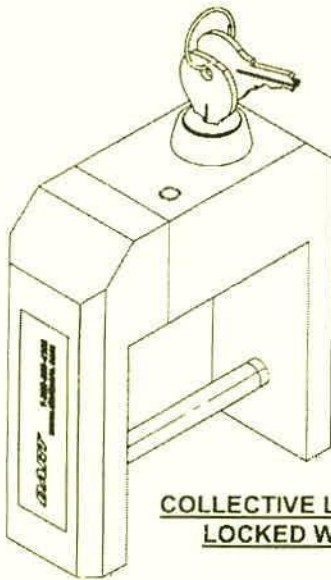
*u 08.09.09*



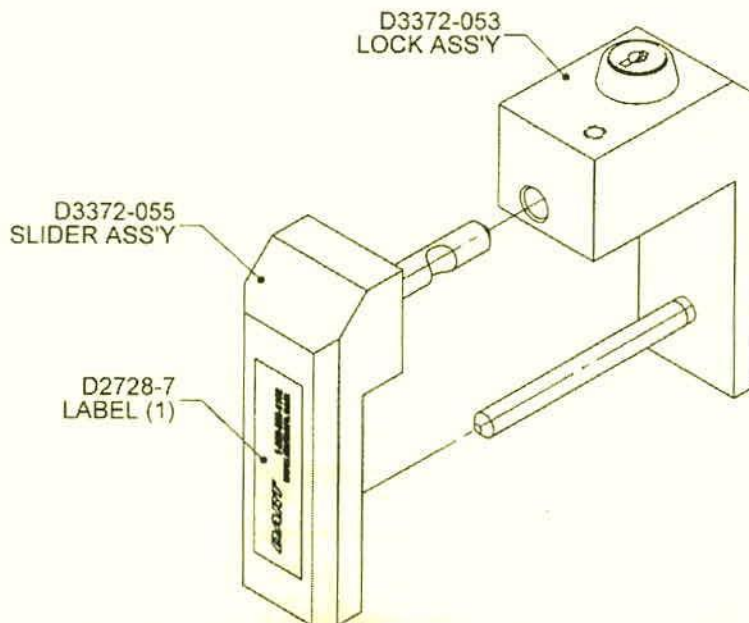
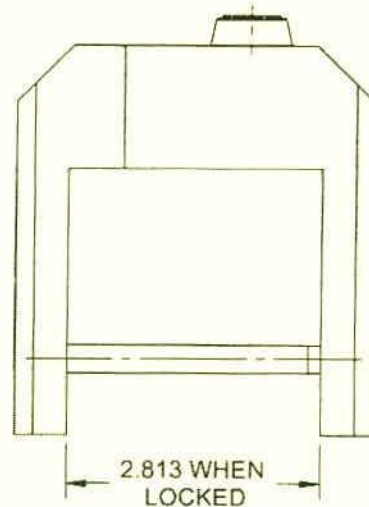


**DART**

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3372</b>	REV. B SHEET 1 OF 8
DATE <b>05.02.23</b>	TITLE <b>COLLECTIVE LOCK</b>		SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



**COLLECTIVE LOCK SHOWN  
LOCKED WITH KEYS**



RELEASED  
05/04/22

W/O  
41527

**D3372-051 AS350 COLLECTIVE LOCK ASS'Y**

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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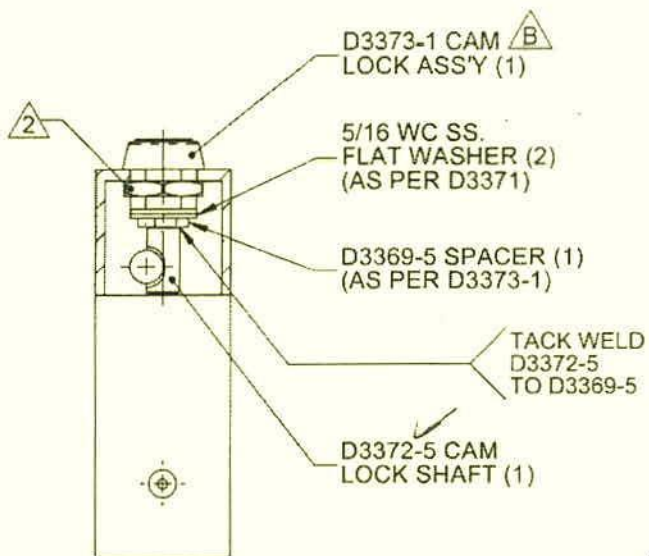
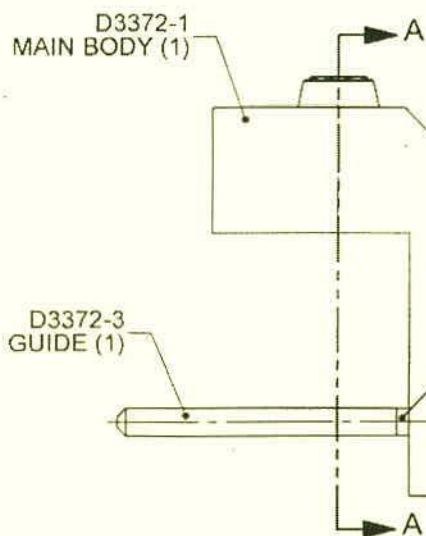
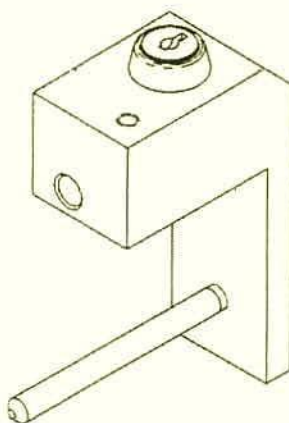
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CHECKED H	APPROVED [Signature]	DRAWING NO. D3372	REV. B SHEET 2 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



**SECTION A-A**

**D3372-053 LOCK ASS'Y**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

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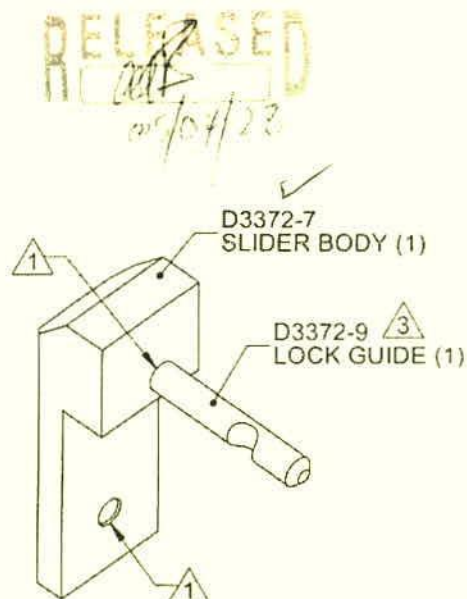
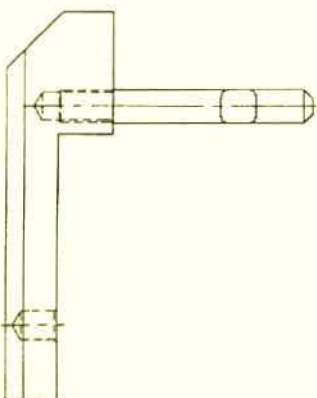
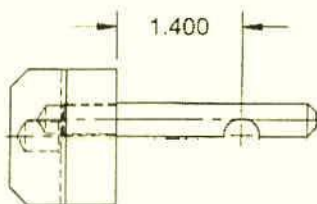
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



### D3372-055 SLIDER ASS'Y

#### NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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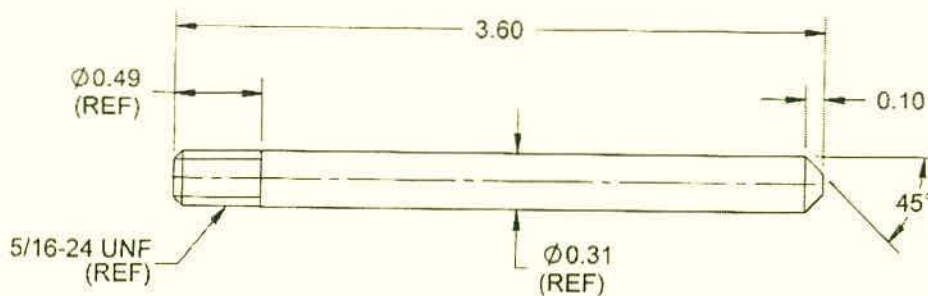


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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

## SPECIFICATION CONTROL DRAWING

RELEASED  
*[Signature]*  
05/04/23



Wb 41527

### D3372-3 GUIDE

#### NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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